

Work Order ID 72153

Tuesday, July 19, 2011 1:47:46 PM



Page 1

Item ID: D2600-3-BENT

Accept



Setup Start



Revision ID:

Item Name: Extrusion Bent

Stop



Start Date: 7/19/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: *H*Date: *11-07-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2600	Rev D1
D2750	F

100



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

Pick qty 1 D2600-3-120 extrusion

0.00

1-Deburr one end of extrusion

2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635

3- cut fwd end of tube as per dwg D2750

4- cut aft end of tube as per dwg D2750

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*PTO**DD**11-7-28**(14)**14 BE 11/08/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2600-3-BENT PAR #: N/A Fault Category: Supplier NCR: Yes No DQA: 11 Date: 11.08.17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11 Date: 11.8.19

NCR: 72153		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-7-28	100	While Bending, Found that ① pc. of extrusion D-2600-3-120 was not properly extruded. Large waves in material.	<i>W</i> <i>11-7-28</i>	Scrap 1 pc of extrusion D2600-3-120 <u>B66973</u>	<i>DD</i> <i>11-7-28</i>	<i>BB</i> <i>11/07/28</i>	<i>W</i> <i>11.07.28</i>	<i>W</i> <i>11/07/28</i>
		Re - Supplier		(SUPPLIER NOTIFIED)	<i>11/08/18</i> <i>CL</i>			

NOTE: Date & initial all entries

Work Order ID 72153

Tuesday, July 19, 2011 1:47:46 PM

Page 2

Item ID: D2600-3-BENT

Accept

Revision ID:

Item Name: Extrusion Bent

Start Date: 7/19/2011 Start Qty: 10.00

Required Date: 7/25/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location LC9

0.00



Packaging

Memo

0.00

Packaging

14 0 8E-11/8/12

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/15

ME
11-08-15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 1:47:53 PM

Page 1

Work Order ID: 72153



Parent Item: D2600-3-BENT



Parent Item Name: Extrusion Bent


Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120  Extrusion Round 3" 350		Manufactured	No			100	Each	76.0000	1	10			



Location

LG

66973

Loc Qty

76

76

Loc Code

15 11-7-28

W/O:		WORK ORDER CHANGES					
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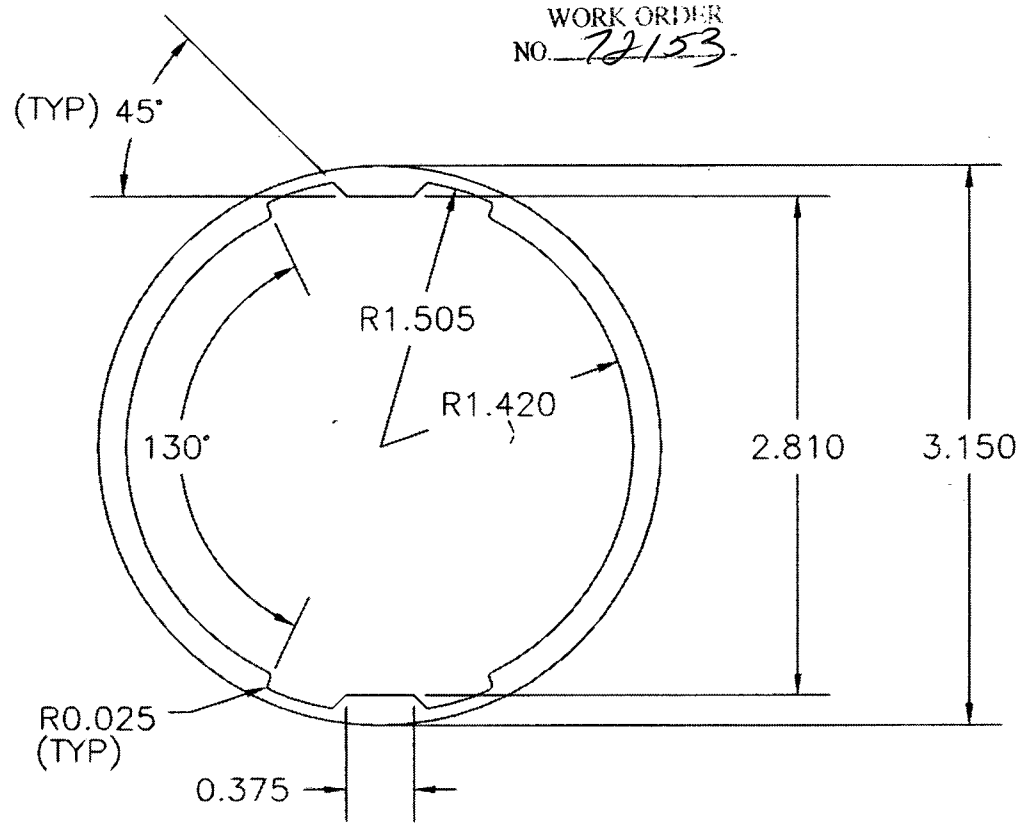
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DART



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DATE	APPROVED	DRAWING NO.	REV. D
98.08.20	<i>[Signature]</i>	D2600	SHEET 3 OF 5
	TITLE	EXTRUSION	SCALE
			1:1

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WORK ORDER
NO. 72153



D2600-3



MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

RELEASED
98.8.25 DS

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL **F**
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL **F**

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NO. **12153**
11-0719

RELEASED
6-27-77

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 09-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RE		
CHECKED	RE	DRAWING NO.	REV. F
MFG. APPR.	RE	D2750	SHEET 1 OF 11
APPROVED	RE	TITLE	SCALE
DE APPR.	RE	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

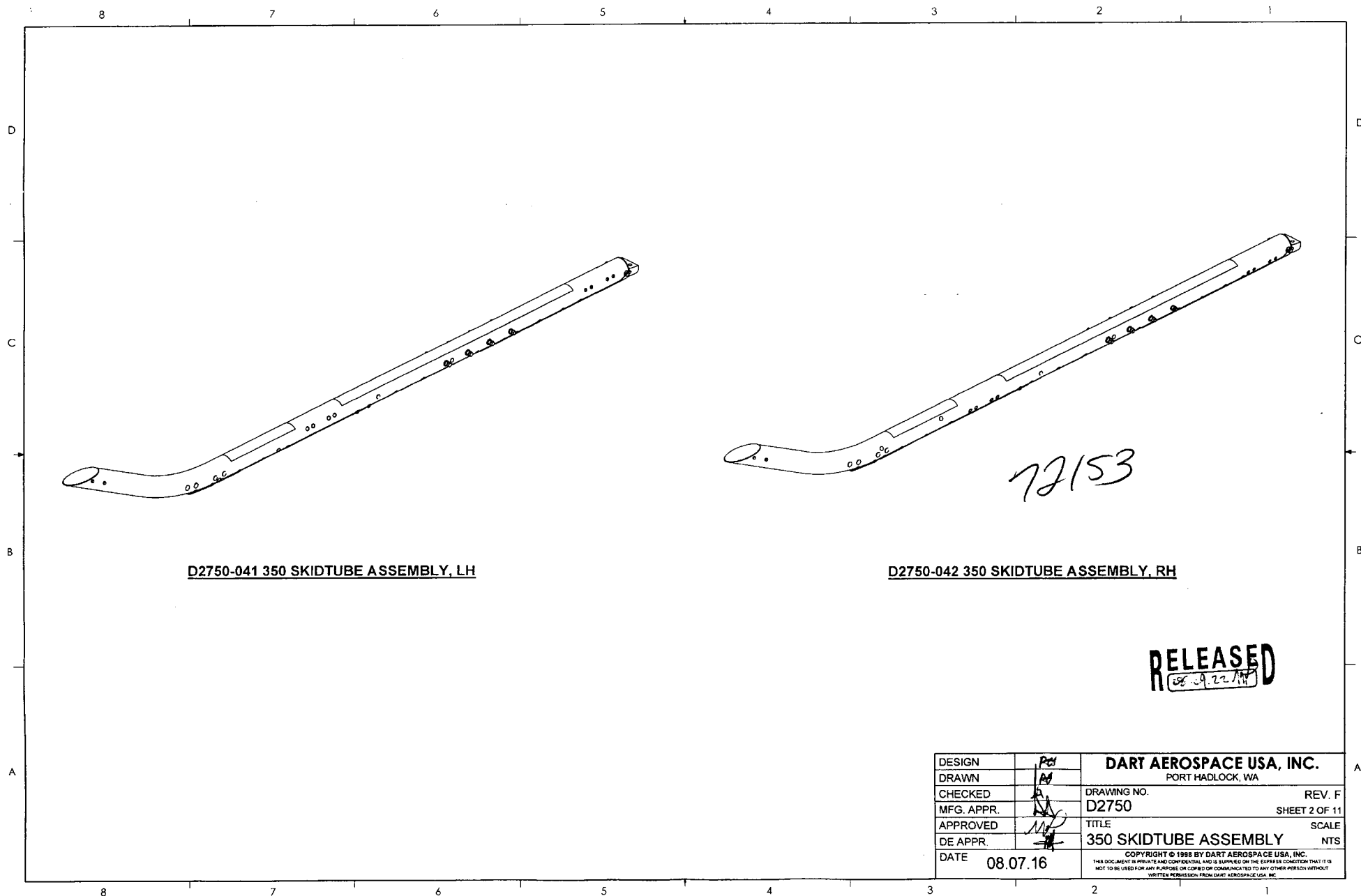
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NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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 88-02274

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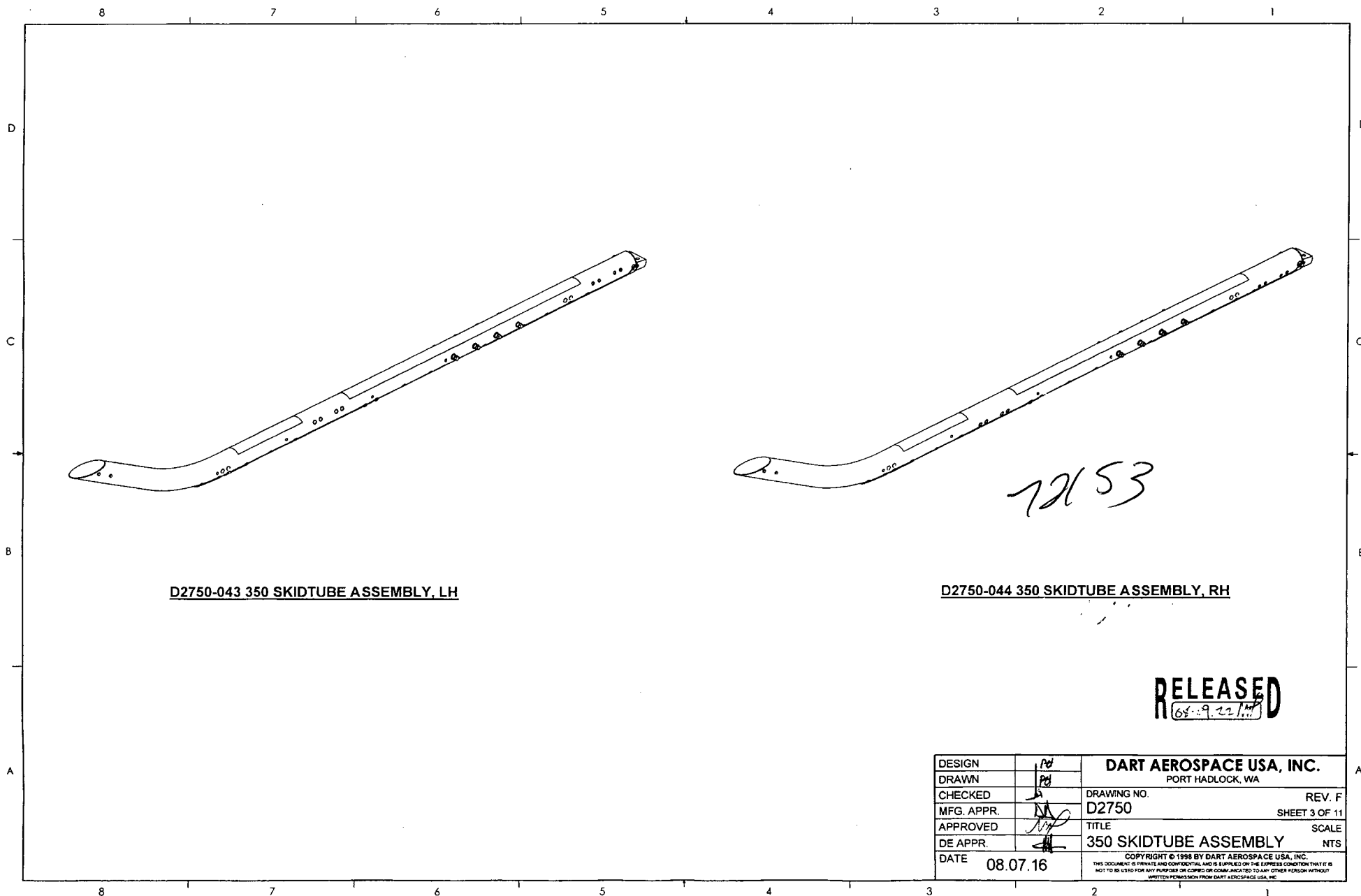
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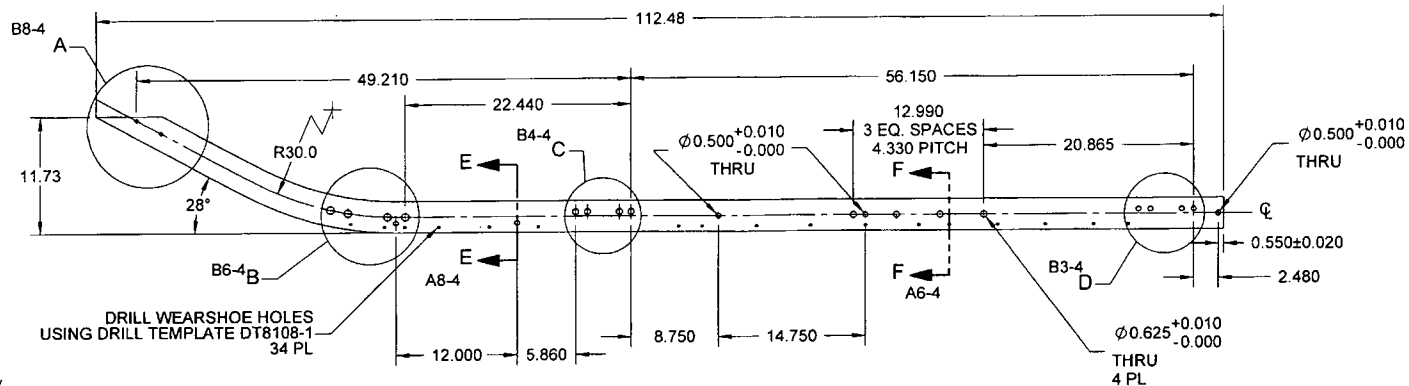
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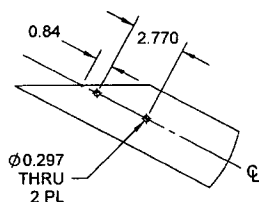
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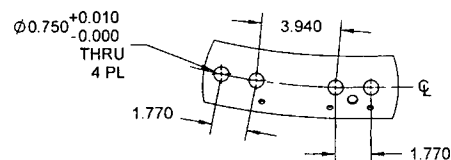
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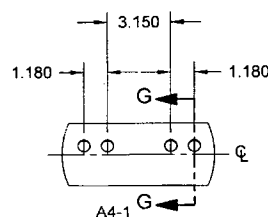
D2750-1 LH SKIDTUBE



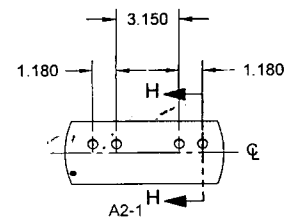
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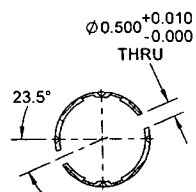
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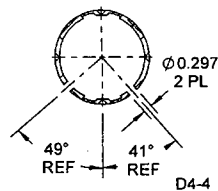
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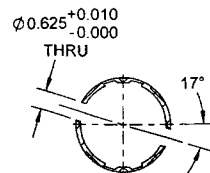
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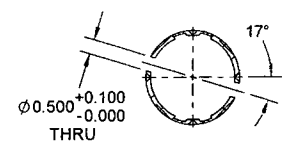
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

72153

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DESIGN	IPM	DART AEROSPACE USA, INC.	
DRAWN	IPM	PORT HADLOCK, WA	
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MFG. APPR.		D2750	SHEET 4 OF 11
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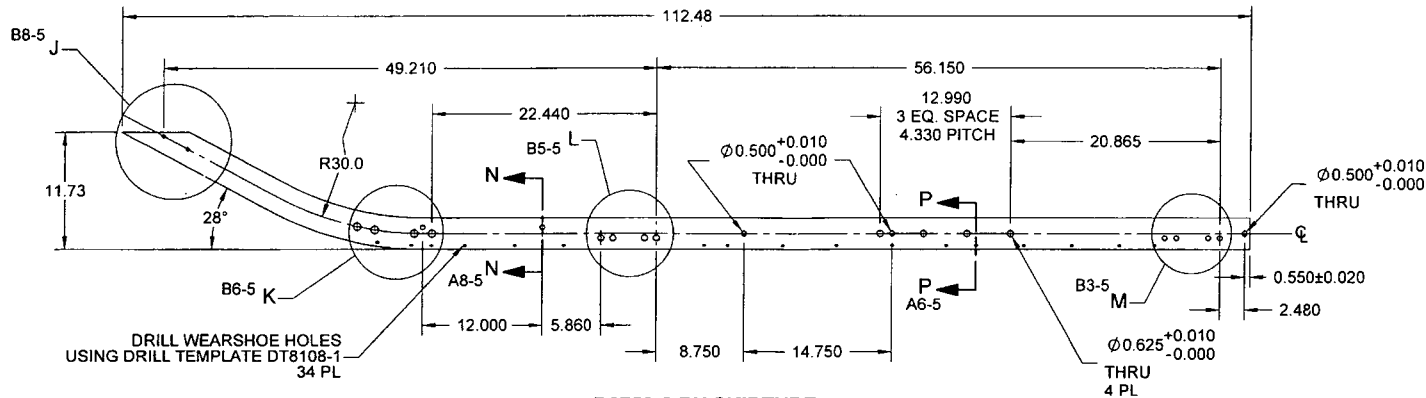
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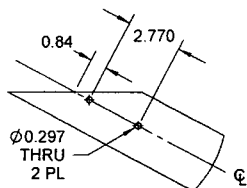
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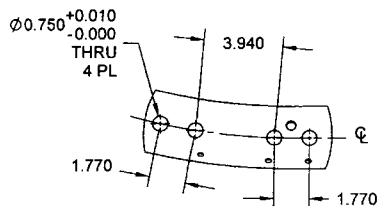
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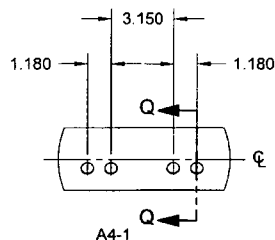
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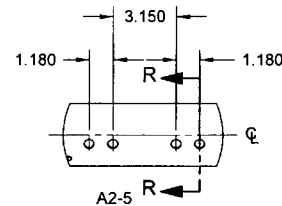
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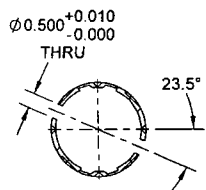
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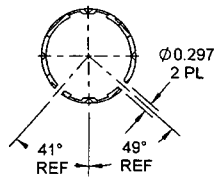
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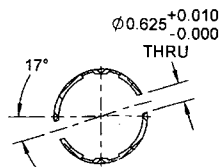
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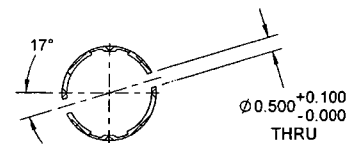
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

72153

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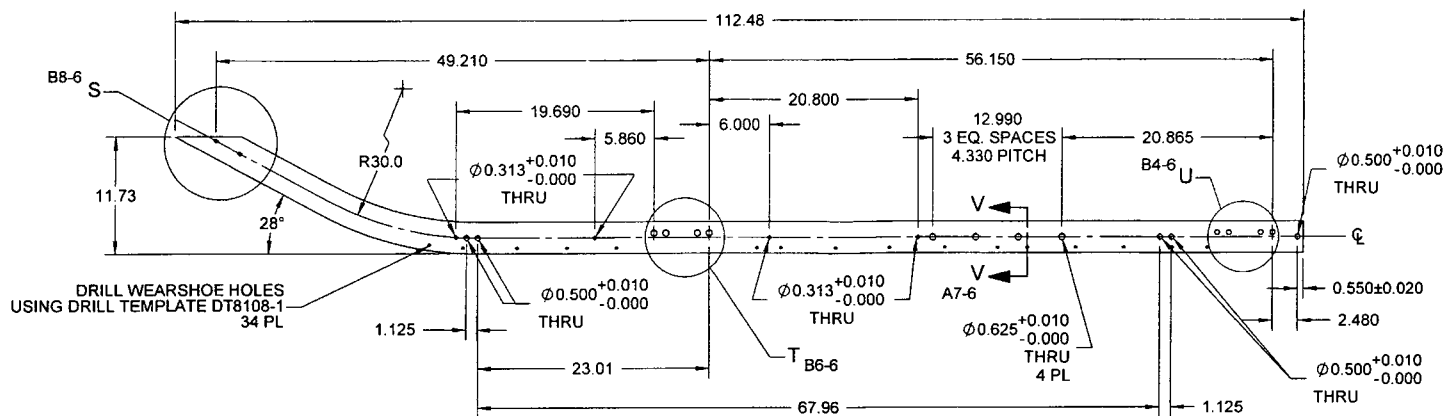
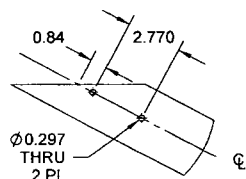
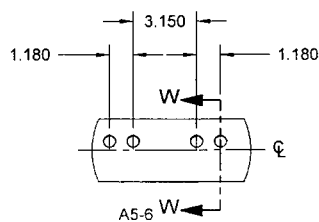
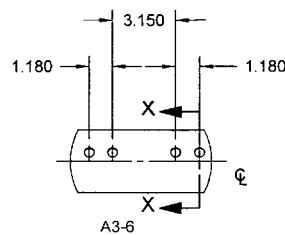
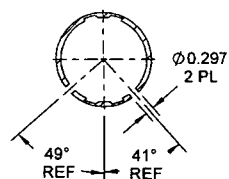
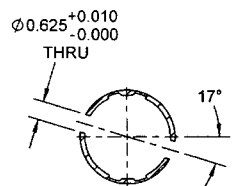
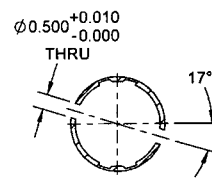
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**D2750-3 LH SKIDTUBE****DETAIL S**
D8-6
SCALE 2X**DETAIL T**
C5-6
SCALE 2X**DETAIL U**
D3-6
SCALE 2X**SECTION V-V**
C4-6
SCALE 3X, 17 PL**SECTION W-W**
B6-6
SCALE 3X, 4 PL**SECTION X-X**
B4-6
SCALE 3X, 4 PL

72153

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08 JUL 1988

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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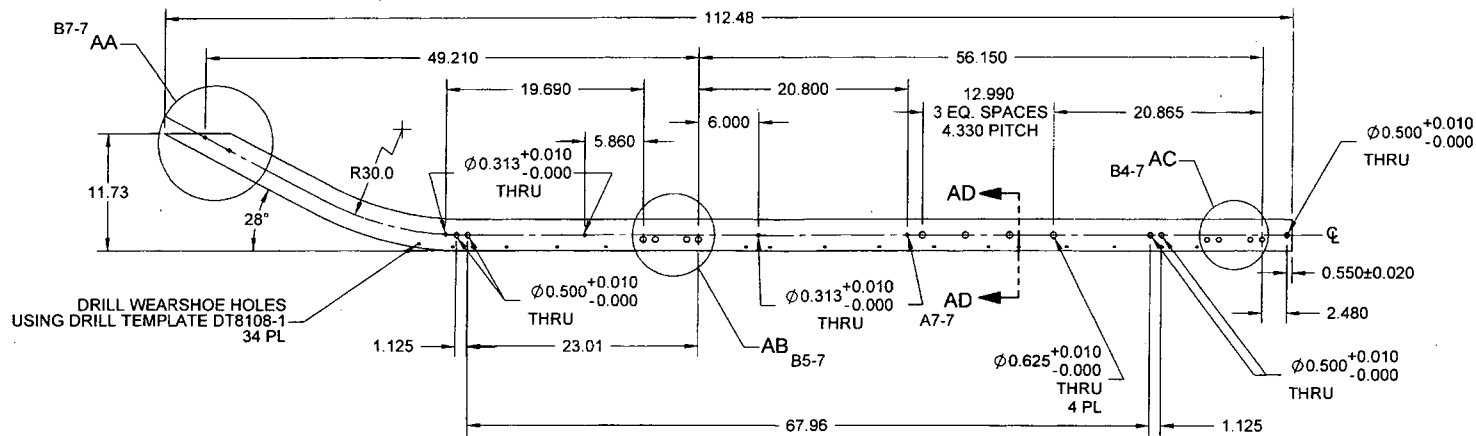
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

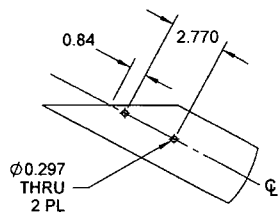
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

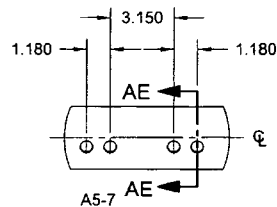
NOTE: Date & initial all entries



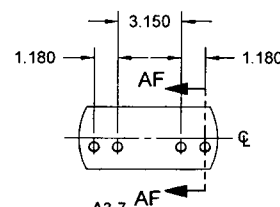
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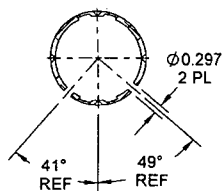
DETAIL AA
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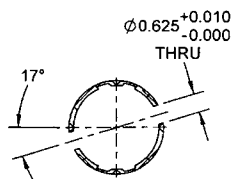
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SCALE 2X



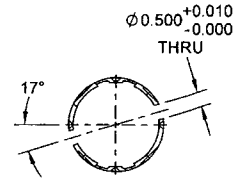
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DESIGN	AG	DART AEROSPACE USA, INC.	
DRAWN	AG	PORT HADLOCK, WA	
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MFG. APPR.	AG	D2750	SHEET 7 OF 11
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DE APPR.	AG	350 SKIDTUBE ASSEMBLY	NTS
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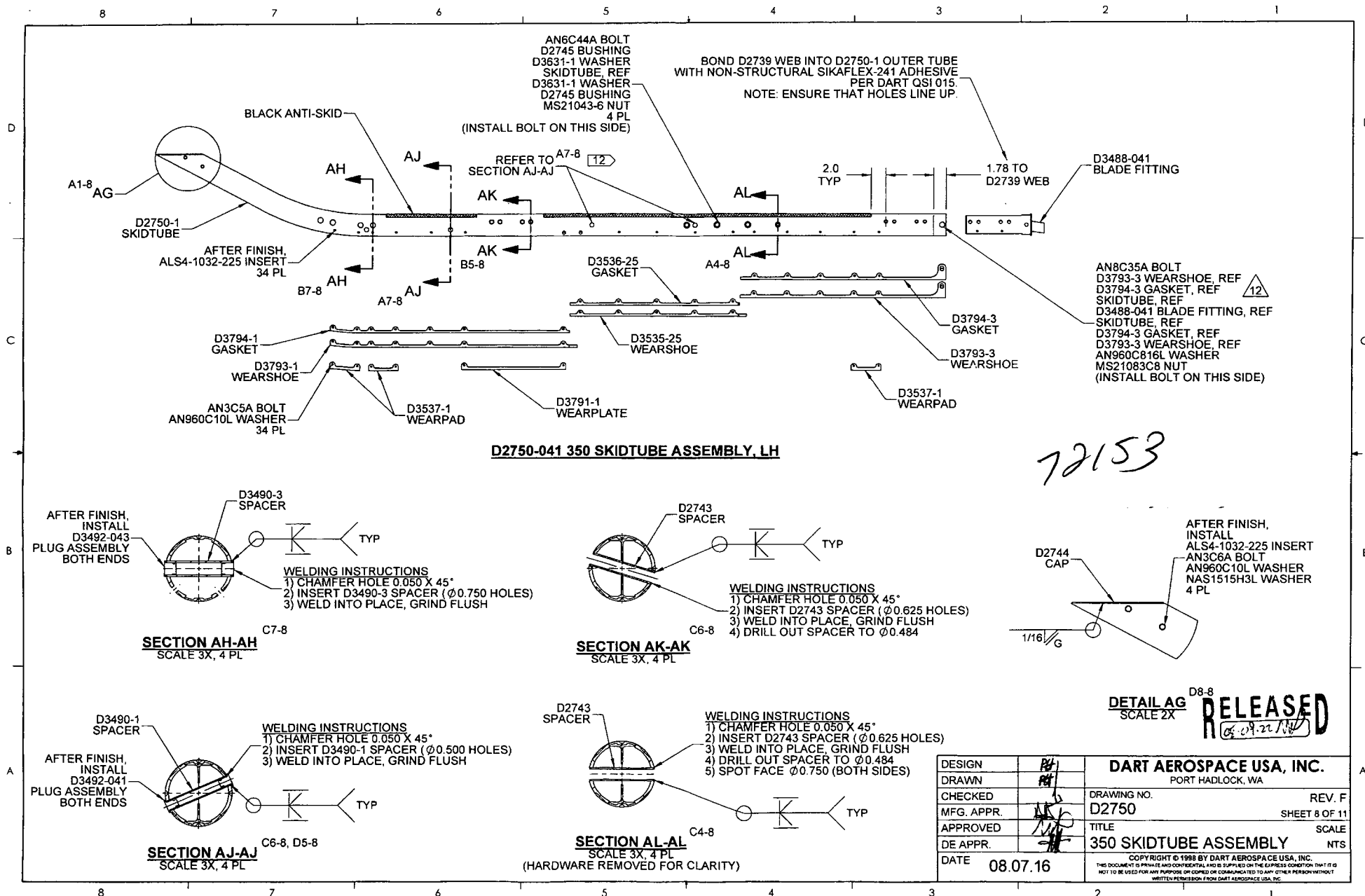
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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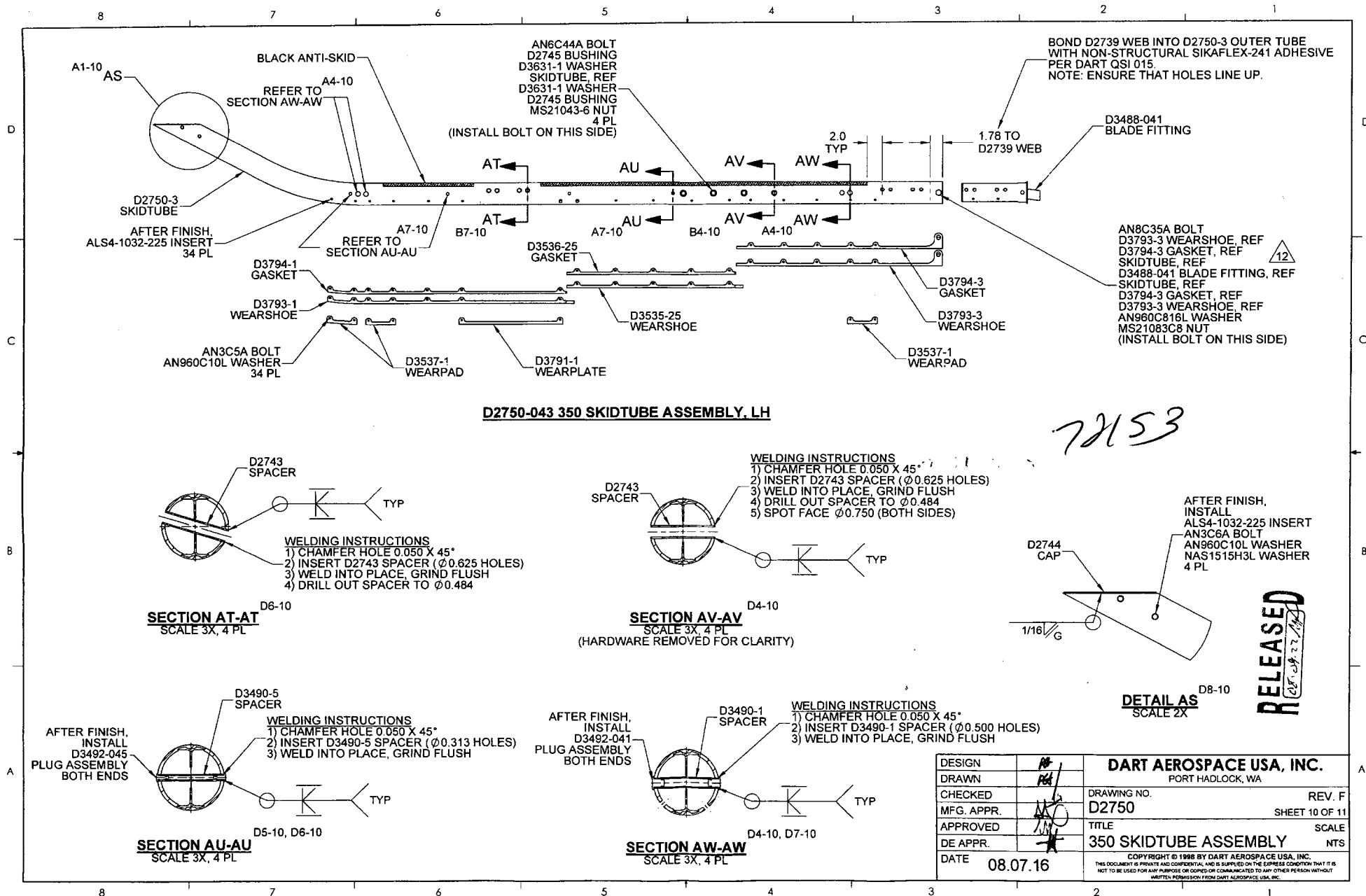
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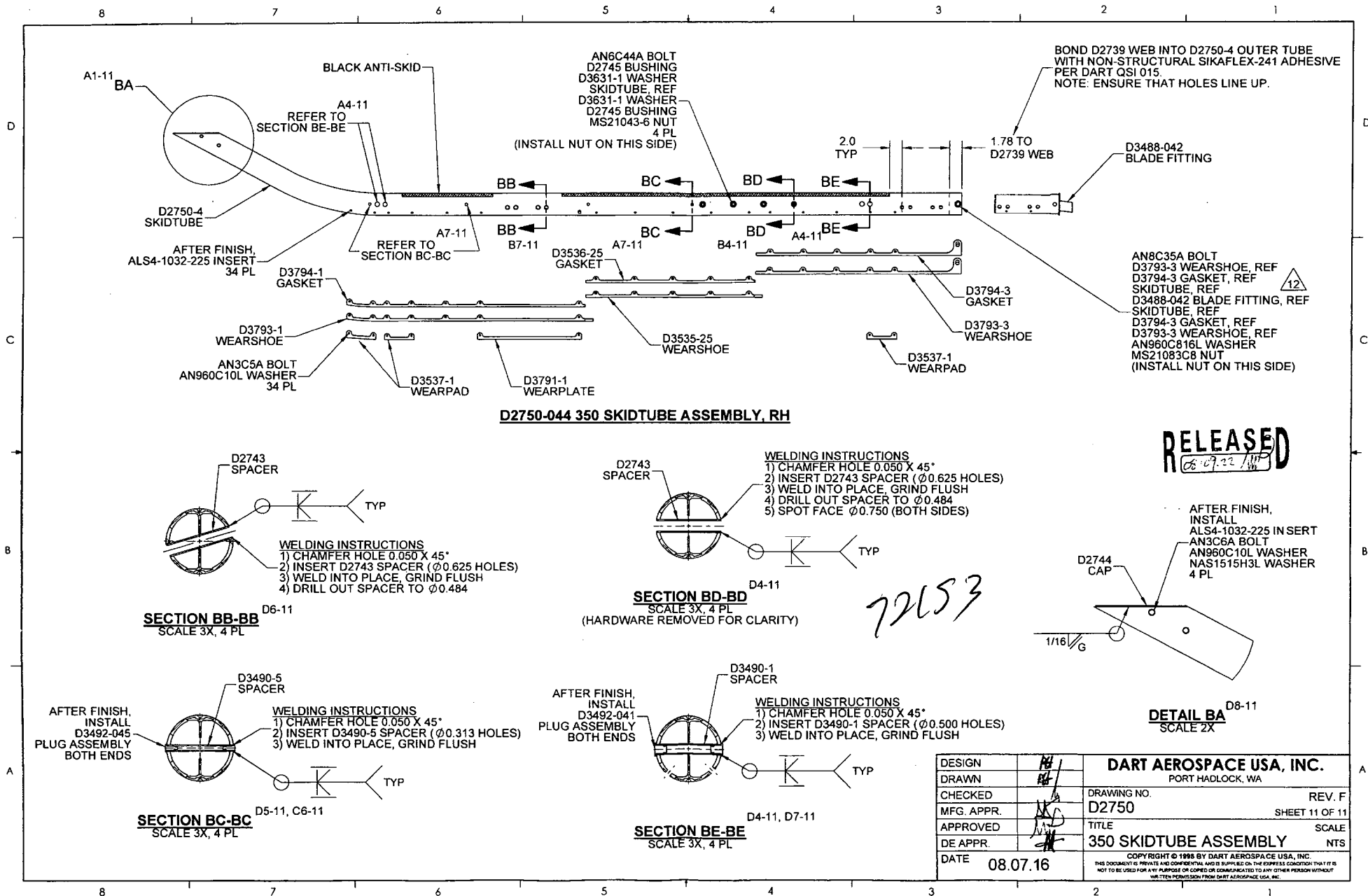
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DRAWN	72153	PORT HADLOCK, WA	
CHECKED	72153	DRAWING NO.	REV. F
MFG. APPR.	72153	D2750	SHEET 11 OF 11
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